

Date: Monday, 08/06/2009 9:24:12 AM
 *User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LUG
Job Number :	48382		
Estimate Number :	11261		
P.O. Number :		Part Number :	D34143
This Issue :	08/06/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3414 REV.B
First Issue :	/ /	Project Number :	N/A
Previous Run :	45802	Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :	JUD 09.06.08	Due Date :	19/06/2009
Comment :	Est A 05.09.13 New issue KJ/JLM		
	Est Rev:B 09-02-26 rev.c as per dwg DD verified by:EC		

Qty: 20 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304B0500X2500	304 BAR .500 x 2.50
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Comment: Qty.: 0.1969 f(s)/Unit Total : 3.9375 f(s)
 304 BAR
 Material: 304/316 SS Bar
 (M304B0.500x02.500)
 Identify for D3414-3
 Batch: M111957

09/06/10

20

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 2.50" x 0.500" x 2.250" long

09/06/10

20

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA569 and Dwg D3414
 Identify as D3414-3Dwg Rev B Folio Rev B

N.A

09/06/11

20

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N.A

09/06/11

20

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

09/06/11

20

W/O: 48382		EST: WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-16	3	BREAK SHARP EDGES 0.050 TO 0.070 LD TO BE ADDED TO DWG D3414 PAR09-027 created for perm change	ND	09/16/17		09.16.16 per QSI 0412	09.16.18

Part No: D3414-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 08/06/2009 9:24:12 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 48382

Part Number: D34143

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *n/a*

Erich

8/09/06/17 x20

FL

9-6-16

20

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/18

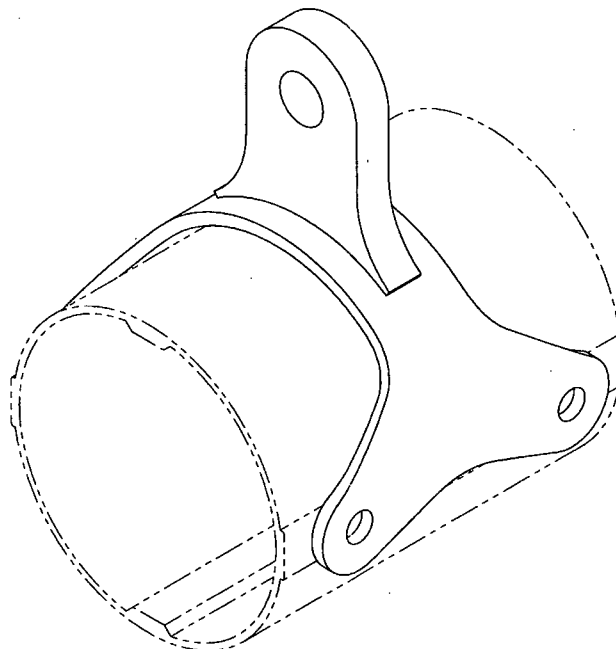
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-06-17

ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
7	1	D3414-1	LUG BRACKET
8	1	D3414-3	LUG



D3414-041 LUG ASSEMBLY

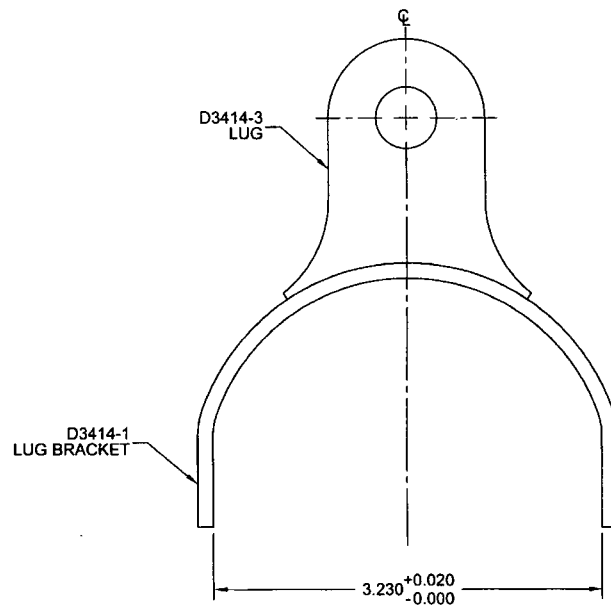
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WORK ORDER
NO. 48382

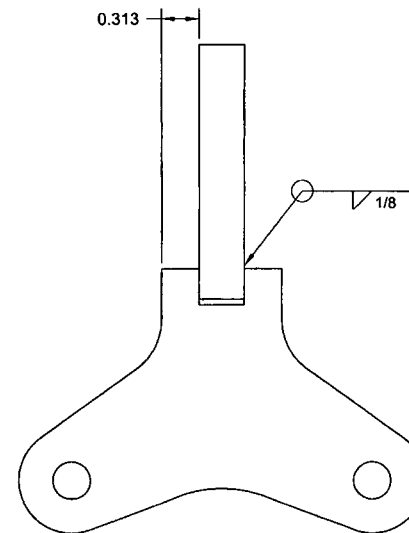
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

B		DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. SHEET 3 ZONE B7 ADDED TOLERANCE TO 3.230 DIM.		AJS	08.09.23
A		NEW ISSUE		CP	05.03.16
REV.	DESCRIPTION			BY	DATE
DESIGN	CP	DART AEROSPACE LTD			
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.	REV. B		
MFG. APPR.		D3414	SHEET 1 OF 3		
APPROVED		TITLE	SCALE		
DE APPR.		LUG ASSEMBLY	NTS		
DATE	08.09.23		<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		



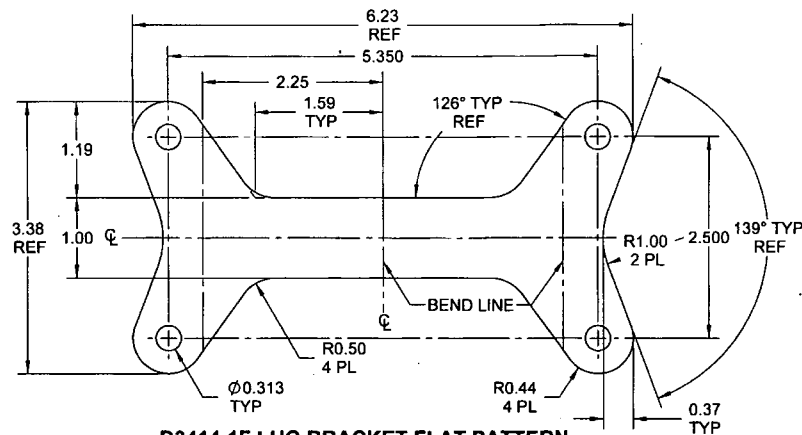
D3414-041 LUG ASSEMBLY



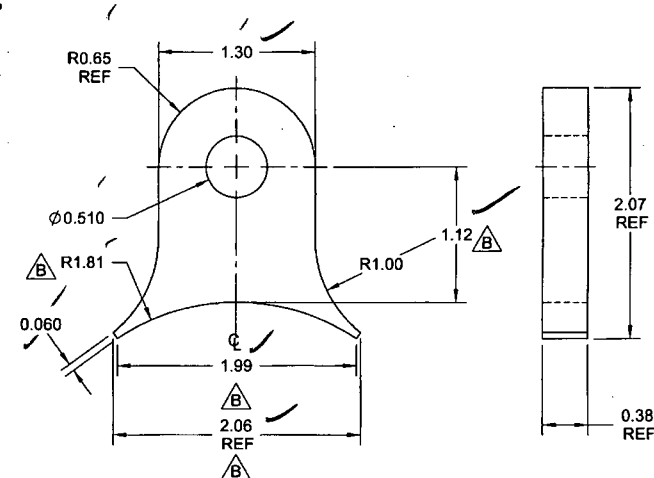
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08/02/18 M

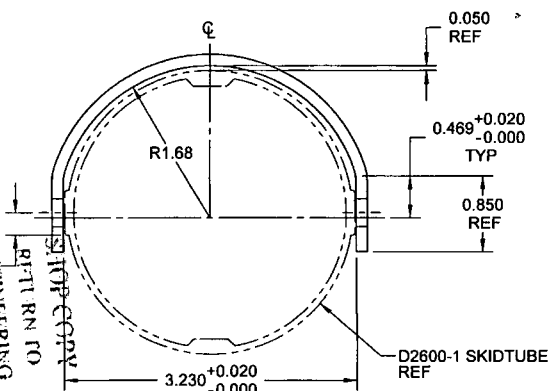
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DRAWN	AJS		
CHECKED		DRAWING NO. D3414	REV. B
MFG. APPR.		SHEET 2 OF 3	
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DE APPR.		LUG ASSEMBLY	NTS
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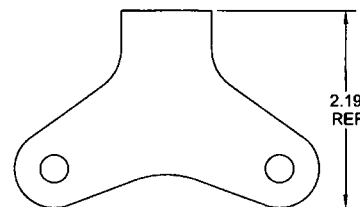
D3414-1F LUG BRACKET FLAT PATTERN



D3414-3 LUG



D3414-1 LUG BRACKET



SIDE VIEW FOR REF ONLY

- NOTES:
- 1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK) PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 REF. DART SPEC. M304S12GA
 - 3: AISI 304/316 STAINLESS STEEL PLATE PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 REF. DART SPEC. M304S
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.010×0.020 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

$-1\% 0.010$ TO 0.020
 $-3\% 0.050$ TO 0.070

RELEASED

DESIGN	QP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AUS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3414	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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